

Work Order ID 79270

January-24-12 11:04:37 AM

\*79270\*

Page 1

Item ID: D206-642-151

Accept

\*N900040100\*

Setup Start \*NS1\*

Revision ID:

Item Name: Replacement Skidtube

Stop \*NS2\*

Start Date: 24/01/2012 Start Qty: 1.00

\*1\*

Cust Item ID:

Required Date: 15/03/2012 Req'd Qty: 1.00

\*1\*

Customer:

Reference:

Approvals:

Process Plan: M.C.J

Date: 12/01/12 Tooling:

Date:

Run Start \*NR1\*

QC:

Date:

SPC (Y/N):

Date:

Stop \*NR2\*

| Sequence ID/<br>Work Center ID | Operation<br>Description | Set Up/<br>Run Hours | Tool ID | Tool # | Plan<br>Code | Accept<br>Qty | Reject<br>Qty | Reject<br>Number | Insp.<br>Stamp |
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|

Draw Nbr

Revision Nbr

D3804

A

IIN-D206-642

O

100

0.00

\*100\*

DOCUMENT CONTROL

DC

0.00

Document Control

Memo

Photocopy bluefile & type labels per PPP D206-642-151

CHG001

N/A

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries

**Work Order ID 79270**

January-24-12 11:04:37 AM

**\*79270\***

Page 2

Item ID: D206-642-151

Accept

**\*N9000040100\***Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Replacement Skidtube

Start Date: 24/01/2012 Start Qty: 1.00

**\*1\***

Cust Item ID:

Required Date: 15/03/2012 Req'd Qty: 1.00

**\*1\***

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start **\*NR1\***

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop **\*NR2\***

| Sequence ID/<br>Work Center ID | Operation<br>Description | Set Up/<br>Run Hours | Tool ID | Tool # | Plan<br>Code | Accept<br>Qty | Reject<br>Qty | Reject<br>Number | Insp.<br>Stamp |
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|

110

0.00

**\*110\***

Skidtubes

Skidtubes

Memo

0.00

1-Deburr Fwd edge of tube

2- Remove ridge on inside of Fwd edge of tube as per Dwg D3804

3-Weld Fwd Cap as per Dwg D3804. Use aluminum rod. Grind D2647 to fit as required.

Pick:

Qty Part Number Description Batch

A/R Aluminum Rod

4-Grind weld flush to cap on top surface only

5-Cut Aft end as per dwg D3804 from front of tube and Deburr

6-Remove inner indexing ridge on Aft end of skidtube as per Dwg D3804

7-Open holes for Aft end cap as per Dwg D3804 with #30 Drill Bit using DT8025.

8-Drill pilot holes using Dt8166 &amp; DT8169D &amp; DT9771.

9-Locate DT8732 from inner Aft saddle hole &amp; 3rd crossbolt hole. Insert D3286-1 doubler using DT8732 &amp; D206-642-241-T1, then locating doubler off of 3/16" holes, cleco DT8732 &amp; doubler leaving DT8732 for added support.

10- Drill D3286-1 doubler rivet holes in tube using # 30 drill, spot drilling doubler at the same time.

12/02/18

SAD 12-02-22

SAD 12-02-22

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
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|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries

# Work Order ID 79270

January-24-12 11:04:37 AM

**\*79270\***

Page 3

Item ID: D206-642-151 Accept **\*N900040100\*** Setup Start **\*NS1\***  
 Revision ID: Stop **\*NS2\***  
 Item Name: Replacement Skidtube  
 Start Date: 24/01/2012 Start Qty: 1.00 **\*1\*** Cust Item ID:  
 Required Date: 15/03/2012 Req'd Qty: 1.00 **\*1\*** Customer:

## Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

| Sequence ID/<br>Work Center ID | Operation<br>Description | Set Up/<br>Run Hours | Tool ID | Tool # | Plan<br>Code | Accept<br>Qty | Reject<br>Qty | Reject<br>Number | Insp.<br>Stamp |
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|

11-Working from the center out, drill # 30 holes into D3286-1 doubler. Cleco each hole as it is being drilled. Verify angle of holes to accommodate rivet heads.

12-Remove 3/16" cleco's only and open GHW holes to Ø0.500" as per Dwg D3804

13-Remove D3286-1 doublers, identify orientation, deburr, then attach them to the workorder

14-Remove indexing edge using DT8741 as per Dwg D3804

15-C'sink GHW rivet holes as per Dwg D3804

16- Open Aft cap hole #6.  
 \*\*\*\*no wearplate holes for this skidtube\*\*\*\*

17-Deburr tube and blow out chips from inside the tube

SAG 12-02-22

120

**\*120\***

QC

Quality Control

QC6- Inspect dimensions to drawing

0.00

Memo

0.00

12' 02' 22 ①

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries

# Work Order ID 79270

**\*79270\***

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January-24-12 11:04:37 AM

Item ID: D206-642-151 Accept **\*N900040100\*** Setup Start **\*NS1\***  
 Revision ID: Stop **\*NS2\***  
 Item Name: Replacement Skidtube

Start Date: 24/01/2012 Start Qty: 1.00 **\*1\*** Cust Item ID:  
 Required Date: 15/03/2012 Req'd Qty: 1.00 **\*1\*** Customer:

## Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

| Sequence ID/<br>Work Center ID | Operation<br>Description  | Set Up/<br>Run Hours | Tool ID | Tool # | Plan<br>Code | Accept<br>Qty | Reject<br>Qty | Reject<br>Number | Insp.<br>Stamp |
|--------------------------------|---|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
| 140                            | Chemical Conversion Coat per QSI005 4.1                                 | 0.00                 |         |        |              |               |               |                  |                |
| <b>*140*</b>                   |   |                      |         |        |              |               |               |                  |                |
| HandFinish                     | Memo  | 0.00                 |         |        |              | ①             |               |                  | SAD 12-02-22   |
| Hand Finishing                 |   |                      |         |        |              |               |               |                  |                |
| 150                            | QC3- Inspect Part Finish  | 0.00                 |         |        |              |               |               |                  |                |
| <b>*150*</b>                   |   |                      |         |        |              |               |               |                  |                |
| QC                             | QC7 Memo  | 0.00                 |         |        |              | 1             | 0             |                  | BER-02-22      |
| Quality Control                |   |                      |         |        |              |               |               |                  | PTO →          |
| 160                            |   | 0.00                 |         |        |              |               |               |                  |                |
| <b>*160*</b>                   |   |                      |         |        |              |               |               |                  |                |
| Skidtubes                      | Skidtubes   | 0.00                 |         |        |              |               |               |                  |                |
| Skidtubes                      | Memo  |                      |         |        |              |               |               |                  |                |
|                                | 1-Open holes to finished size as per Dwg D3804, (without cutting fluid) |                      |         |        |              |               |               |                  | - BB 12/02/22  |
|                                | 2-C'sink crossbolt spacer holes as per Dwg D3804(without cutting fluid) |                      |         |        |              |               |               |                  | 3 SAD 12-02-22 |
|                                | 3-Deburr and blow out all chips from inside the tube                    |                      |         |        |              |               |               |                  |                |

| W/O:     |      | WORK ORDER CHANGES                |    |          |     |                                     |                          |
|----------|------|-----------------------------------|----|----------|-----|-------------------------------------|--------------------------|
| DATE     | STEP | PROCEDURE CHANGE                  | By | Date     | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
| 12/02/22 | 150  | SHOULD BE QLT.<br>Already updated | BE | 12/02/22 |     |                                     | S<br>12/03/22            |
|          |      |                                   |    |          |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries



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Sikaflex expire date: 2012-68-13

1 0 BE12/02/22

1 SAND 12-02-20

25

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries

**\*79270\***

January-24-12 11:04:37 AM

**Accept**

**\*N900040100\***

Setup Start \*NS1\*

Stop \*NS2\*

**Start Date:** 24/01/2012      **Start Qty:** 1.00

**\* 1 \***

**Cust Item ID:**

**Required Date:** 15/03/2012      **Req'd Qty:** 1.00

**\* 1 \***

**Customer:**

**Reference:**

**Approvals:**      **Process Plan:** \_\_\_\_\_ **Date:** \_\_\_\_\_ **Tooling:** \_\_\_\_\_ **Date:** \_\_\_\_\_

Run Start \*NR1\*

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop \*NR2\*

### Operation Description

### Set Up/ Run Hours

| Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|---------|--------|-----------|------------|------------|---------------|-------------|
|---------|--------|-----------|------------|------------|---------------|-------------|

190

QC5- Inspect part completeness to step on W/O

0.00

**\*190\***

QC

## Memo

0.00

## Quality Control

1 Ø BE 12/02/23

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries

# Work Order ID 79270

**\*79270\***

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January-24-12 11:04:37 AM

Item ID: D206-642-151 Accept **\*N900040100\*** Setup Start **\*NS1\***  
 Revision ID: Stop **\*NS2\***  
 Item Name: Replacement Skidtube  
 Start Date: 24/01/2012 Start Qty: 1.00 **\*1\*** Cust Item ID:  
 Required Date: 15/03/2012 Req'd Qty: 1.00 **\*1\*** Customer:  
 Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

| Sequence ID/<br>Work Center ID | Operation<br>Description | Set Up/<br>Run Hours | Tool ID | Tool # | Plan<br>Code | Accept<br>Qty | Reject<br>Qty | Reject<br>Number | Insp.<br>Stamp |
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
| 200                            | Skidtubes                | 0.00                 |         |        |              |               |               |                  |                |

**\*200\***

Skidtubes

Skidtubes

## Memo

0.00

1-remove alodine from around hole and prepare for welding

2-Prep per QSI 005 and Insert D2649 crossbolt spacers. Weld as per QSI 004 and Dwg D3804. Remember to back drill each hole to 0.25" before welding the other side. Use aluminum rod.

Pick:

QtyPart NumberDescriptionBatch

A/RAluminum Rod M120164

3-Grind welds flush as per Dwg D3804.

4-Using DT8733, insert (2) D3286-3 spacers as per QSI 004 and Dwg D3804. Remember to back drill each hole to Ø0.402" before welding other side. Use SS rod as required.

A/RSS Rod NONE

5-Counterbore 5/16" x 0.750" deep except 7th hole from Aft end as per Dwg D3804. Deburr

*BE 12/02/23*

*DP 12-2-28*

*DP 12-2-28*

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries

**\*79270\***

January-24-12 11:04:37 AM

**Accept**

**\*N900040100\***

Setup Start \*NS1\*

Stop \*NS2\*

**Start Date:** 24/01/2012      **Start Qty:** 1.00

**\* 1 \***

**Cust Item ID:**

**Required Date:** 15/03/2012      **Req'd Qty:** 1.00

**\* 1 \***

**Customer:**

**Reference:**

**Approvals:**      **Process Plan:** \_\_\_\_\_ **Date:** \_\_\_\_\_ **Tooling:** \_\_\_\_\_ **Date:** \_\_\_\_\_

Run Start \*NR1\*

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop \*NR2\*

| Sequence ID/<br>Work Center ID | Operation<br>Description | Set Up/<br>Run Hours | Tool ID | Tool # | Plan<br>Code | Accept<br>Qty | Reject<br>Qty | Reject<br>Number | Insp.<br>Stamp |
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|

210

0.00

**\*210\***

## HandFinishing

0.00

HandFinish

## Memo

## Hand Finishing

Install D2680-041 Nut Plate as per Dwg D3804

215

QC9- Inspect visual per QSI004- Fusion Welds

0.00

**\*215\***

QC

## Memo

0.00

## Quality Control

220

QC10- Inspect visual per QSI004- ground welds

0.00

\*220\*

OC

## Memo

0.00

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
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|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries



# Work Order ID 79270

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Item ID: D206-642-151 Accept **\*N900040100\*** Setup Start **\*NS1\***  
 Revision ID: Stop **\*NS2\***  
 Item Name: Replacement Skidtube  
 Start Date: 24/01/2012 Start Qty: 1.00 **\*1\*** Cust Item ID:  
 Required Date: 15/03/2012 Req'd Qty: 1.00 **\*1\*** Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

| Sequence ID/<br>Work Center ID | Operation<br>Description | Set Up/<br>Run Hours | Tool ID | Tool # | Plan<br>Code | Accept<br>Qty | Reject<br>Qty | Reject<br>Number | Insp.<br>Stamp |
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|

|     |   |      |  |  |  |  |  |  |  |
|-----|---|------|--|--|--|--|--|--|--|
| 230 | QC5- Inspect part completeness to step on W/O | 0.00 |  |  |  |  |  |  |  |
|-----|---|------|--|--|--|--|--|--|--|

**\*230\***

QC Memo

Quality Control

|     |                              |      |  |  |  |  |  |  |  |
|-----|------------------------------|------|--|--|--|--|--|--|--|
| 240 | Pressure Wash per QSI005 4.3 | 0.00 |  |  |  |  |  |  |  |
|-----|------------------------------|------|--|--|--|--|--|--|--|

**\*240\***

HandFinish Memo

Hand Finishing

|     |  |      |  |  |  |  |  |  |  |
|-----|--|------|--|--|--|--|--|--|--|
| 250 | White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum | 0.00 |  |  |  |  |  |  |  |
|-----|--|------|--|--|--|--|--|--|--|

**\*250\***

Powdercoat Memo

Powder Coating

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

7:50  
3200 F  
8:20

1 ~~Q~~ m/l (2p) 12/02/29.

1X m-l 12/03/01

m120222

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries

# Work Order ID 79270

**\*79270\***

Page 10

January-24-12 11:04:37 AM

Item ID: D206-642-151 Accept **\*N900040100\*** Setup Start **\*NS1\***  
 Revision ID: Stop **\*NS2\***  
 Item Name: Replacement Skidtube  
 Start Date: 24/01/2012 Start Qty: 1.00 **\*1\*** Cust Item ID:  
 Required Date: 15/03/2012 Req'd Qty: 1.00 **\*1\*** Customer:  
 Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

| Sequence ID/<br>Work Center ID | Operation<br>Description   | Set Up/<br>Run Hours | Tool ID | Tool # | Plan<br>Code | Accept<br>Qty | Reject<br>Qty | Reject<br>Number | Insp.<br>Stamp |
|--------------------------------|--|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
| 260                            | QC3- Inspect Part Finish   | 0.00                 |         |        |              |               |               |                  |                |
| <b>*260*</b>                   |  |                      |         |        |              |               |               |                  |                |
| QC                             | Memo   | 0.00                 |         |        |              |               |               |                  |                |
| Quality Control                |  |                      |         |        |              |               |               |                  |                |
| 270                            | HandFinishing  | 0.00                 |         |        |              |               |               |                  |                |
| <b>*270*</b>                   |  |                      |         |        |              |               |               |                  |                |
| HandFinish                     | Memo   | 0.00                 |         |        |              |               |               |                  |                |
| Hand Finishing                 | 1-Install D2651-3 O-Rings on D2651-1 plugs with Petroleum Jelly and install plugs as per Dwg D3804. Clean excess adhesive. |                      |         |        |              |               |               |                  |                |

IRH d M 12/03/04

IRH d M 12/03/06

RH C

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries

January-24-12 11:04:37 AM

**Item ID:** D206-642-151

**Accept**

**\*N900040100\***

Setup Start \*NS1\*

Revision ID:

**Item Name:** Replacement Skidtube

Stop \*NS2\*

**Start Date:** 24/01/2012      **Start Qty:** 1.00

**\* 1 \***

**Cust Item ID:**

**Required Date:** 15/03/2012      **Req'd Qty:** 1.00

**\* 1 \***

**Customer:**

**Reference:**

**Approvals:**      **Process Plan:** \_\_\_\_\_      **Date:** \_\_\_\_\_      **Tooling:** \_\_\_\_\_      **Date:** \_\_\_\_\_

Run Start \*NR1\*

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop \*NR2\*

| Sequence ID/<br>Work Center ID | Operation<br>Description | Set Up/<br>Run Hours | Tool ID | Tool # | Plan<br>Code | Accept<br>Qty | Reject<br>Qty | Reject<br>Number | Insp.<br>Stamp |
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|

280

0.00

\*280\*

## HandFinishing

0.00

HandFinish

## Memo

## Hand Finishing

1-Install D2646 Aft Cap and seal with Sikaflex. Clean excess adhesive

A/RSikaflex-291 11119.500

Sikaflex expire date: 12/08

2- Install wearplate as per dwg

2-Wing Walk as per Dwg D3804 and OSI 005 4.4

Batch: 1A120123

290

### QC3- Inspect Part Finish

0.00

\*290\*

QC

## Memo

0.00

## Quality Control

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                                |                                 |                |                           |                       |                          |
|------|------|----------------------------------|--------------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action<br>Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng           | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                                |                                 |                |                           |                       |                          |
|      |      |                                  |                                |                                 |                |                           |                       |                          |
|      |      |                                  |                                |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries

# Work Order ID 79270

**\*79270\***

Page 12

January-24-12 11:04:37 AM

Item ID: D206-642-151 Accept **\*N900040100\*** Setup Start **\*NS1\***  
 Revision ID: Stop **\*NS2\***  
 Item Name: Replacement Skidtube

Start Date: 24/01/2012 Start Qty: 1.00 **\*1\*** Cust Item ID:  
 Required Date: 15/03/2012 Req'd Qty: 1.00 **\*1\*** Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

| Sequence ID/<br>Work Center ID                | Operation<br>Description   | Set Up/<br>Run Hours | Tool ID | Tool #     | Plan<br>Code | Accept<br>Qty | Reject<br>Qty | Reject<br>Number | Insp.<br>Stamp |
|---|--|----------------------|---------|------------|--------------|---------------|---------------|------------------|----------------|
| 300<br><b>*300*</b><br>QC<br>Quality Control  | QC5- Inspect part completeness to step on W/O<br><br>Memo  | 0.00<br><br>0.00     |         | 5/17/03/05 |              |               |               |                  |                |
| 310<br><b>*310*</b><br>Packaging<br>Packaging | Packaging<br><br>Memo<br>Identify and pack for shipping as per PPP D206-642-151<br>Location: _____<br>PPP Rev: _____ | 0.00<br><br>0.00     |         | PPP 71453  |              |               |               |                  | 12/3/12 SP     |
| 320<br><b>*320*</b><br>QC<br>Quality Control  | QC21- Final Inspection - Work Order Release<br><br>Memo  | 0.00<br><br>0.00     |         |            |              |               |               |                  | 12/3/12        |

12-03-12

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                                |                                 |                |                           |                       |                          |
|------|------|----------------------------------|--------------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action<br>Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng           | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                                |                                 |                |                           |                       |                          |
|      |      |                                  |                                |                                 |                |                           |                       |                          |
|      |      |                                  |                                |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries



# Picklist Print

January-24-12 11:04:41 AM

Page 1

Work Order ID: 79270

**\*79270\***

Parent Item: D206-642-151

**\*D206-642-151\***

Parent Item Name: Replacement Skidtube

Start Date: 24/01/2012

Required Date: 15/03/2012

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP REV:A 10.12.08 PER IIN REV:N DD VERF:EC IPP  
REV:B 11.09.16 PER IIN REV:O DD VERF:EC

| Component Item ID/<br>Item Name                     | Replacement<br>Item ID | Mfg/<br>Purch | Bin<br>Item | Primary<br>Location | Last<br>Location | Route<br>Seq ID | Unit of<br>Measure | Qty on<br>Hand  | Qty per Kit | Total<br>Qty | Qty<br>Issued | Date<br>Issued | Status |
|---|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|-----------------|-------------|--------------|---------------|----------------|--------|
| D2620<br><b>*D2620*</b><br>Skidtube, 206 Skidtube   |                        | Manufactured  | No          |                     |                  | 110             | Each               | 8.0000          | 1           | 1            |               |                |        |
|   |                        |               |             | <u>Location</u>     |                  | <u>Loc Qty</u>  |                    | <u>Loc Code</u> |             |              |               |                |        |
|   |                        |               |             | LG                  |                  | 8               |                    |                 |             |              |               |                |        |
|   |                        |               |             |                     | 71617            | 2               |                    |                 |             |              |               |                |        |
|   |                        |               |             |                     | 77997            | 6               |                    |                 |             |              |               |                |        |
| D2647<br><b>*D2647*</b><br>Cap                      |                        | Manufactured  | No          |                     |                  | 110             | Each               | 133.0000        | 1           | 1            |               |                |        |
|   |                        |               |             | <u>Location</u>     |                  | <u>Loc Qty</u>  |                    | <u>Loc Code</u> |             |              |               |                |        |
|   |                        |               |             | LG002               |                  | 133             |                    |                 |             |              |               |                |        |
|   |                        |               |             |                     | 73826            | 24              |                    |                 |             |              |               |                |        |
|   |                        |               |             |                     | 75482            | 109             |                    |                 |             |              |               |                |        |
| CR3212-4-04<br><b>*CR3212-4-04*</b><br>Cherry Rivet |                        | Purchased     | No          |                     |                  | 180             | Each               | 10,198.00       | 52          | 52           |               |                |        |
|   |                        |               |             | <u>Location</u>     |                  | <u>Loc Qty</u>  |                    | <u>Loc Code</u> |             |              |               |                |        |
|   |                        |               |             | ST331               |                  | 364             |                    |                 |             |              |               |                |        |
|   |                        |               |             |                     | 116471           | 78              |                    |                 |             |              |               |                |        |
|   |                        |               |             |                     | 117816           | 3               |                    |                 |             |              |               |                |        |
|   |                        |               |             |                     | 118686           | 1               |                    |                 |             |              |               |                |        |
|   |                        |               |             |                     | 118840           | 16              |                    |                 |             |              |               |                |        |
|   |                        |               |             |                     | 119017           | 256             |                    |                 |             |              |               |                |        |
|   |                        |               |             |                     | 119075           | 10              |                    |                 |             |              |               |                |        |
|   |                        |               |             | st510               |                  | 9834            |                    |                 |             |              |               |                |        |
|   |                        |               |             |                     | 119075           | 9834            |                    |                 |             |              |               |                |        |

\*\*

1 12/02/18

\*\*

BE 12/02/21

\*\*

SAD 12-02-22

52

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries

# Picklist Print

January-24-12 11:04:41 AM

Page 2

Work Order ID: 79270

**\*79270\***

Parent Item: D206-642-151

**\*D206-642-151\***

Parent Item Name: Replacement Skidtube

Start Date: 24/01/2012

Required Date: 15/03/2012

Start Qty: 1.00

Required Qty: 1.00

D2654-1

Manufactured No

180

Each

25.0000

1

1

**\*D2654-1\***

Web

\*\*

SAD 12-02-22

Location

Loc Qty

Loc Code

LG

25

77278

2

77279

10

77280

3

77281

10

880054

①

D3286-1

Manufactured No

180

Each

231.0000

2

2

**\*D3286-1\***

Doubler

\*\*

SAD 12-02-22

Location

Loc Qty

Loc Code

LG002

233

74872

6

78014

109

ST046

-2

76772

116

2

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries

# Picklist Print

January-24-12 11:04:41 AM

Page 3

Work Order ID: 79270

**\*79270\***

Parent Item: D206-642-151

**\*D206-642-151\***

Parent Item Name: Replacement Skidtube

Start Date: 24/01/2012

Required Date: 15/03/2012

Start Qty: 1.00

Required Qty: 1.00

D2649

Manufactured No

200

Each

559.0000

19

19

**\*D2649\***

Cross Bolt Spacer

**\*\***

BE 12/02/23  
B78019 x19

Location

Loc Qty

Loc Code

LG

40

77574

40

LG001

519

65317

1

68224

2

68507

11

71355

2

72704

2

72841

11

73390

8

73857

21

73858

53

73859

4

73860

4

78020

400

D3286-3

Manufactured No

200

Each

128.0000

2

2

**\*D3286-3\***

Spacer

**\*\***

BE 01/02/27

Location

Loc Qty

Loc Code

LG

100

78015

100

LG001

28

74117

1

76773

27

2

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries

# Picklist Print

January-24-12 11:04:41 AM

Work Order ID: 79270

**\*79270\***

Parent Item: D206-642-151

**\*D206-642-151\***

Parent Item Name: Replacement Skidtube

Start Date: 24/01/2012

Required Date: 15/03/2012

Start Qty: 1.00

Required Qty: 1.00

D2680-041

Manufactured No

210

Each

110.0000

1

1

**\*D2680-041\***

Nut Plate

\*\*

DP 12-2-28

Location

Loc Qty

Loc Code

ST013

14

75479

14

ST019

96

76790

96

CR3212-4-03

Purchased

No

210

Each

1,650.000

2

2

**\*CR3212-4-03\***

Cherry Rivet

\*\*

DP 12-2-28

Location

Loc Qty

Loc Code

FP002

660

114859

660

ST331

990

110139

2

119017

988

AN960JD416

NAS1149D0463J

Purchased

No

210

Each

0.0000

1

1

**\*AN960JD416\***

Washer

\*\*

M118384 (K1) M1103105

CCR264SS3-3

Purchased

No

210

Each

885.0000

2

2

**\*CCR264SS3-3\***

Cherry Rivet

\*\*

DP 12-2-28

Location

Loc Qty

Loc Code

ST331

885

113973

2

117849

135

119017

748

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries



# Picklist Print

January-24-12 11:04:41 AM

Page 5

Work Order ID: 79270

**\*79270\***

Parent Item: D206-642-151

**\*D206-642-151\***

Parent Item Name: Replacement Skidtube

Start Date: 24/01/2012

Required Date: 15/03/2012

Start Qty: 1.00

Required Qty: 1.00

MS27039-4-06

Purchased

No

210

Each

277.0000

1

1

**\*MS27039-4-06\***

Screw

\*\*

11 12/03/06

Location

Loc Qty

Loc Code

ST292

277

119075

277

X1

D2651-1

Manufactured

No

270

Each

527.0000

6

6

**\*D2651-1\***

Plug

\*\*

11 12/03/06

Location

Loc Qty

Loc Code

FP001

413

57869

1

66445

10

69018

2

70827

2

70839

8

70942

14

71037

53

73827

23

FP-A

114

77559

114

78124

300

X6

D2651-3

Manufactured

No

270

Each

2,547.000

6

6

**\*D2651-3\***

O-Ring

\*\*

11 12/03/06

Location

Loc Qty

Loc Code

FP001

547

61962

12

73828

535

X6

FP-A

2000

78126

2000

January-24-12 11:04:41 AM

Shop Packet Print

Page 5

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                                |                                 |                |                           |                       |                          |
|------|------|----------------------------------|--------------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action<br>Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng           | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                                |                                 |                |                           |                       |                          |
|      |      |                                  |                                |                                 |                |                           |                       |                          |
|      |      |                                  |                                |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries

# Picklist Print

January-24-12 11:04:41 AM

Page 6

Work Order ID: 79270

**\*79270\***

Parent Item: D206-642-151

**\*D206-642-151\***

Parent Item Name: Replacement Skidtube

Start Date: 24/01/2012

Required Date: 15/03/2012

Start Qty: 1.00

Required Qty: 1.00

D3873-1

Manufactured No

280 Each

509.0000 14 14

**\*D3873-1\***

Bushing

\*\*

1379560 (x14) Jul 12/03/06

Location

Loc Qty

Loc Code

ST067

509

64760

1

68247

4

73829

19

73830

2

78017

483

D2646

Manufactured No

280 Each

96.0000 1 1

**\*D2646\***

Aft Cap

\*\*

1378018 (x1) Jul 12/03/06

Location

Loc Qty

Loc Code

FP002

96

62678

5

68280

5

70945

1

71038

4

71070

2

73294

1

73825

78

D3805-041

Manufactured No

280 Each

0.0000 1 1

**\*D3805-041\***

Wearplate Assembly Fwd, Low Gear

\*\*

1378002 (x1) Jul 12/03/06

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                                |                                 |                |                           |                       |                          |
|------|------|----------------------------------|--------------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action<br>Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng           | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                                |                                 |                |                           |                       |                          |
|      |      |                                  |                                |                                 |                |                           |                       |                          |
|      |      |                                  |                                |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries

# Picklist Print

January-24-12 11:04:41 AM

Page 7

Work Order ID: 79270

**\*79270\***

Parent Item: D206-642-151

**\*D206-642-151\***

Parent Item Name: Replacement Skidtube

Start Date: 24/01/2012

Required Date: 15/03/2012

Start Qty: 1.00

Required Qty: 1.00

MS27039-1-08

Purchased

No

280

Each

1,907.000

2

2

**\*MS27039-1-08\***

Screw

\*\*

HL 12/03/06

Location

Loc Qty

Loc Code

ST291

1907

117423

77

118910

2

119075

328

119109

500

120308

1000

XZ

MS21042L3

Purchased

No

280

Each

5,641.000

7

7

**\*MS21042L3\***

Nut

\*\*

HL 12/03/06

Location

Loc Qty

Loc Code

ST300

5641

117441

16

117885

32

118451

5

118927

3

119017

5120

119075

465

XZ

D3805-045

Manufactured

No

280

Each

7.0000

1

1

**\*D3805-045\***

Wearplate Assembly Aft, Low Gear

\*\*

1378010611 HL 12/03/06

Location

Loc Qty

Loc Code

FP001

7

73817

1

74896

1

76786

5

AN960JD10L

NAS1149D0332J

Purchased

No

280

Each

0.0000

2

2

**\*AN960JD10L\***

Washer

\*\*

1119042 (x2) HL 12/03/06

January-24-12 11:04:41 AM

Shop Packet Print

Page 7

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                                |                                 |                |                           |                       |                          |
|------|------|----------------------------------|--------------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action<br>Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng           | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                                |                                 |                |                           |                       |                          |
|      |      |                                  |                                |                                 |                |                           |                       |                          |
|      |      |                                  |                                |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries

# Picklist Print

January-24-12 11:04:41 AM

Work Order ID: 79270

**\*79270\***

Parent Item: D206-642-151

**\*D206-642-151\***

Parent Item Name: Replacement Skidtube

Start Date: 24/01/2012

Required Date: 15/03/2012

Start Qty: 1.00

Required Qty: 1.00

AN3-37A Purchased No

280 Each 1,231.000 7 7

**\*AN3-37A\***

Bolt

\*\*

*24 12/03/06*

Location

Loc Qty

Loc Code

ST353

1231

117619

4

119086

1227

*X7*

NAS1149D0363J Purchased No

280 Each 3,670.000 7 7

**\*NAS1149D0363.J\***

Washer

\*\*

*24 12/03/06*

Location

Loc Qty

Loc Code

ST298

3670

117601

61

118077

1

118612

18

119537

1041

120142

1549

120308

1000

*X7*

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                                |                                 |                |                           |                       |                          |
|------|------|----------------------------------|--------------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action<br>Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng           | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                                |                                 |                |                           |                       |                          |
|      |      |                                  |                                |                                 |                |                           |                       |                          |
|      |      |                                  |                                |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries



| ITEM | Qty<br>-041 | Qty<br>-043 | Part Number  | Description                     |
|------|-------------|-------------|--------------|---------------------------------|
| 1    | X           |             | D3804-041    | SKIDTUBE ASSEMBLY, 206 A/B LOW  |
| 2    |             | X           | D3804-043    | SKIDTUBE ASSEMBLY, 206 A/B HIGH |
| 5    | 1           | 1           | D2600-1-160  | EXTRUSION                       |
| 6    | 1           | 1           | D2646        | AFT CAP                         |
| 7    | 1           | 1           | D2647        | CAP                             |
| 8    | 19          | 20          | D2649        | CROSS BOLT SPACER               |
| 9    | 6           | 8           | D2651-1      | PLUG                            |
| 10   | 6           | 8           | D2651-3      | O-RING                          |
| 11   |             | 1           | D2654-3      | WEB                             |
| 12   | 1           |             | D2654-1      | WEB                             |
| 13   | 1           | 1           | D2680-041    | NUT PLATE                       |
| 14   | 2           | 2           | D3286-1      | DOUBLER                         |
| 15   | 2           | 2           | D3286-3      | STUD                            |
| 21   | 2           | 2           | AN960JD10L   | WASHER                          |
| 22   | 1           | 1           | AN960JD416   | WASHER                          |
| 23   | 2           | 2           | CCR264SS3-3  | RIVET                           |
| 24   | 2           | 2           | CR3212-4-03  | RIVET                           |
| 25   | 52          | 52          | CR3212-4-04  | RIVET                           |
| 26   | 2           | 2           | MS27039-1-08 | SCREW                           |
| 27   | 1           | 1           | MS27039-4-06 | SCREW                           |

#### NOTES

- 1) MATERIAL: N/A
- 2) FINISH: -CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
-POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) BLACK ANTI-SKID PAINT AS INDICATED TO 0.5 ABOVE LOCATION RIDGE PER DART QSI 005 4.4
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 7) IDENTIFICATION: NONE
- 8) WEIGHT: 12.5 lb
- 9) WELD PER DART QSI 004
- 10) BENDING: DAMAGE TOLERANCE ON FWD BEND:  
THERE SHOULD BE NO VISIBLE WRINKLES IN THE BEND FROM THE GROUND TO A HEIGHT OF 5 INCHES ABOVE THE GROUND. IT IS ACCEPTABLE TO POLISH OUT GOUGES UP TO 0.020 DEEP IN THE BENT PORTION OF THE TUBE. A MAXIMUM REDUCTION IN DIAMETER OF 0.150" IS ACCEPTABLE IN THE BENT PORTION OF THE TUBE.
- 11) BOND WEB INTO OUTER TUBE WITH SIKAFLEX-241/291 ADHESIVE PER DART QSI 015
- 12) INSERT D2651-1 PLUG C/W D2651-3 O-RING IN HOLES MARKED 'P' (BOTH SIDES OF TUBE)

SUPPLY  
 UNCLAS  
 NO. 79230 M.L.J  
 12/01/25

RELEASED  
 UP 09-03-03  
 per ECN 09-536

|            |             |    |          |
|------------|-------------|----|----------|
| A          | NEW ISSUE   | MB | 08.07.07 |
| REV.       | DESCRIPTION | BY | DATE     |
| DESIGN     |             |    |          |
| DRAWN      |             |    |          |
| CHECKED    |             |    |          |
| MFG. APPR. |             |    |          |
| APPROVED   |             |    |          |
| DE APPR.   |             |    |          |
| DATE       | 08.07.07    |    |          |

|  |              |
|--|--------------|
| DART AEROSPACE USA, INC  |              |
| PORT HADLOCK, WA   |              |
| DRAWING NO.  | REV. A       |
| D3804  | SHEET 1 OF 5 |
| TITLE  | SCALE        |
| SKIDTUBE ASSEMBLY, 206A/B  | NTS          |
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| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

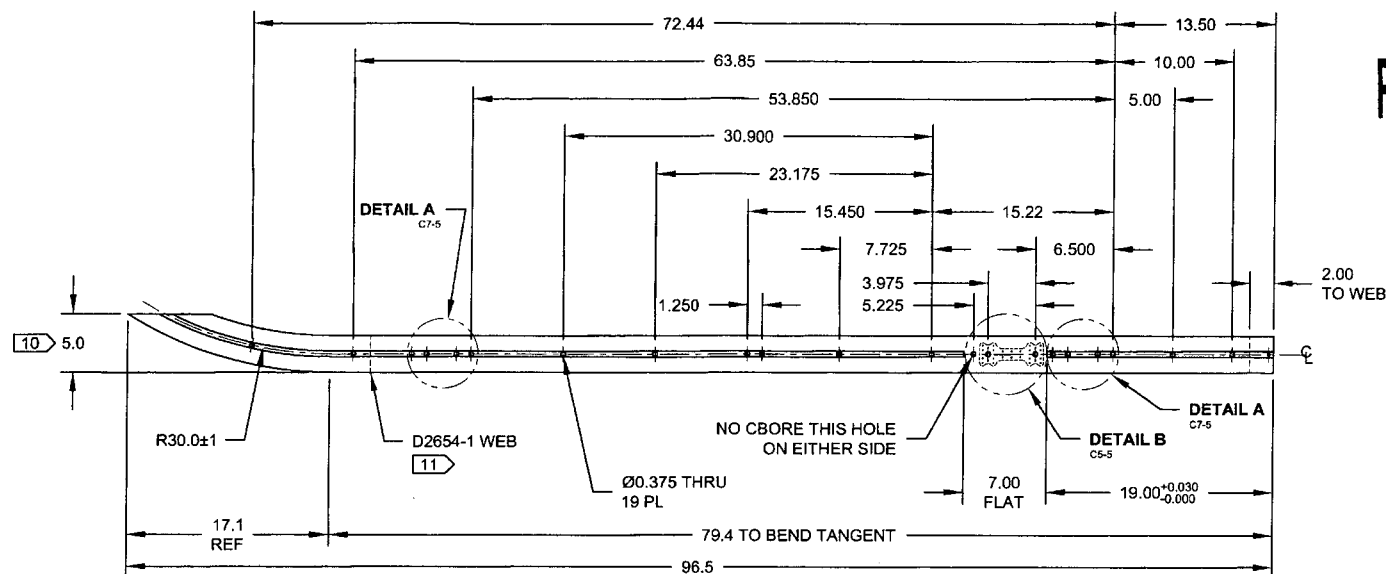
Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

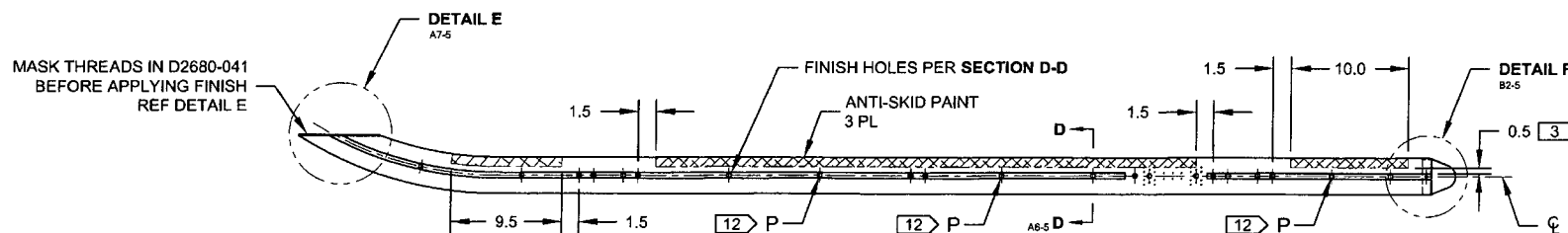
**NOTE:** Date & initial all entries

72270

RELEASED  
09.13.03



**D3804-041 BENDING/DRILLING DETAIL**



**D3804-041 ASSEMBLY/FINISHING DETAIL**

|            |          |  |              |
|------------|----------|--|--------------|
| DESIGN     | 99       | <b>DART AEROSPACE USA, INC</b>   |              |
| DRAWN      | J        | PORT HADLOCK, WA   |              |
| CHECKED    | 6        | DRAWING NO.  | REV. A       |
| MFG. APPR. | E        | D3804  | SHEET 2 OF 5 |
| APPROVED   | 12       | TITLE  | SCALE        |
| DE APPR.   | 12       | SKIDTUBE ASSEMBLY, 206A/B  | NTS          |
| DATE       | 08.07.07 | <small>COPYRIGHT © 2008 BY DART AEROSPACE USA, INC<br/>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSES OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small> |              |

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

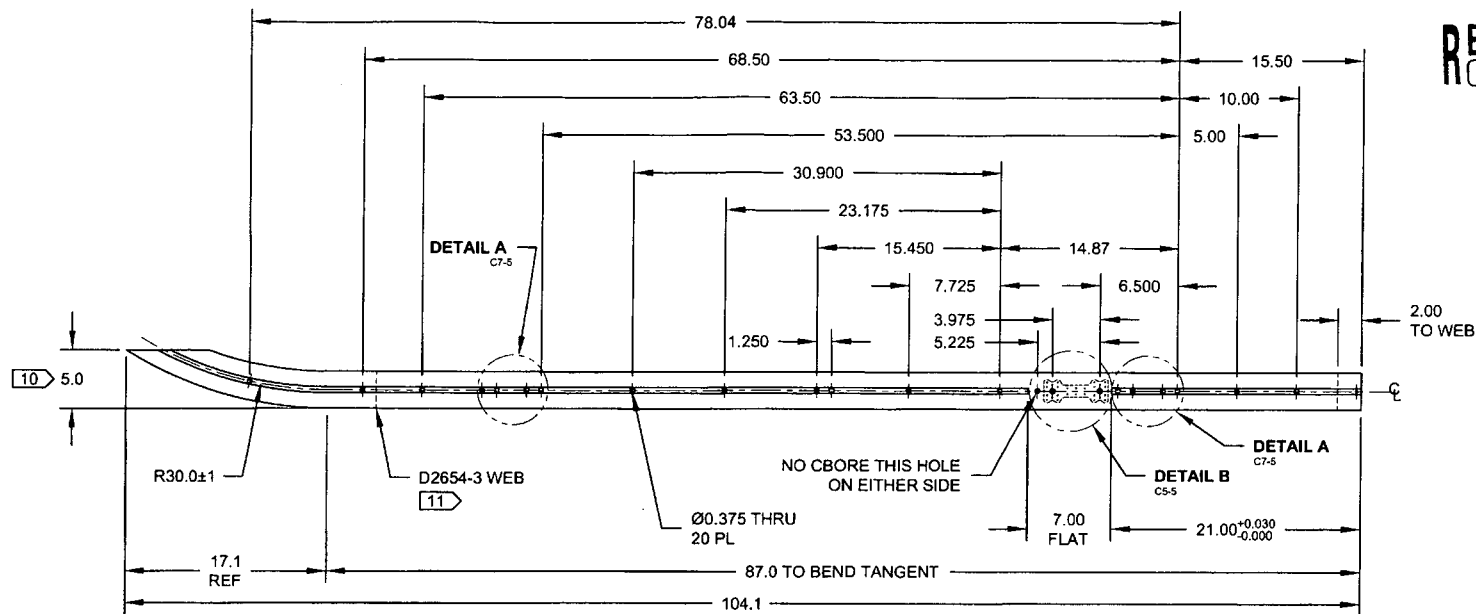
Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                                |                                 |                |                           |                       |                          |
|------|------|----------------------------------|--------------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action<br>Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng           | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                                |                                 |                |                           |                       |                          |
|      |      |                                  |                                |                                 |                |                           |                       |                          |
|      |      |                                  |                                |                                 |                |                           |                       |                          |

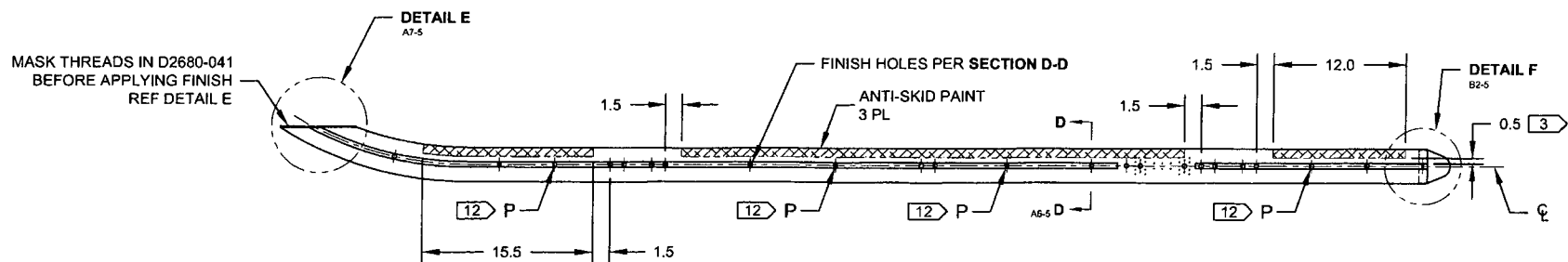
**NOTE:** Date & initial all entries

79270

RELEASED  
09.03.03



**D3804-043 BENDING/DRILLING DETAIL**



**D3804-043 ASSEMBLY/FINISHING DETAIL**

|   |          |   |              |
|---|----------|---|--------------|
| DESIGN  | 99       | <b>DART AEROSPACE USA, INC</b>              |              |
| DRAWN   | 99       | PORT HADLOCK, WA                            |              |
| CHECKED   | 99       | DRAWING NO.                                 | REV. A       |
| MFG. APPR.  | 99       | D3804                                       | SHEET 3 OF 5 |
| APPROVED  | 99       | TITLE                                       | SCALE        |
| DE APPR.  | 99       | SKIDTUBE ASSEMBLY, 206A/B                   | NTS          |
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| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

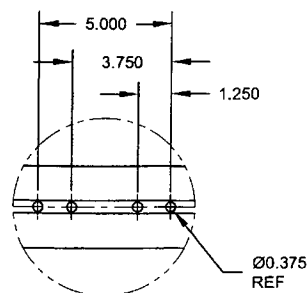
Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                                |                                 |                |                           |                       |                          |
|------|------|----------------------------------|--------------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action<br>Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng           | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                                |                                 |                |                           |                       |                          |
|      |      |                                  |                                |                                 |                |                           |                       |                          |
|      |      |                                  |                                |                                 |                |                           |                       |                          |

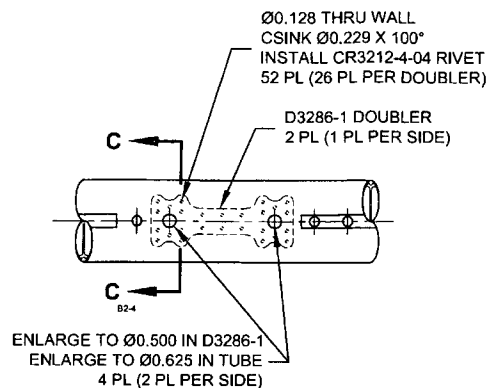
**NOTE:** Date & initial all entries

79270

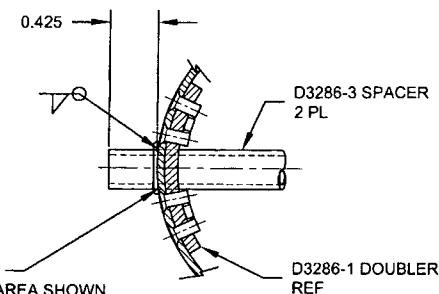
RELEASED  
09.03.07



**DETAIL A**  
D6-2  
C2-2  
D6-3  
C2-3  
SCALE NONE

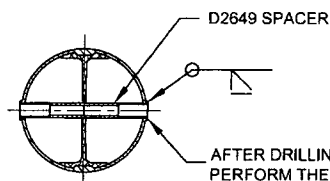


**DETAIL B**  
C3-2  
C3-3  
SCALE NONE



- TO INSTALL D3286-1/3:
1. GRIND OFF FLANGE IN AREA SHOWN, FLUSH WITH OUTSIDE SURFACE OF ROUND TUBE
  2. LOCATE & DRILL D3286-1 DOUBLER USING DT3286-1T1
  3. ENLARGE HOLES IN D3286-1 TO 0.500
  4. ENLARGE HOLES IN TUBE TO 0.625 AND CHAMFER HOLE 0.03 X 45°
  5. RIVET D3286-1 TO TUBE
  6. INSERT D3286-3 SPACER
  7. WELD IN PLACE AND GRIND FLUSH

**SECTION C-C**  
C6-4  
PARTIAL SECTION  
SCALE NONE



- AFTER DRILLING AND BENDING ASSEMBLY PERFORM THE FOLLOWING FOR 0.375 HOLES ONLY:
1. CHAMFER HOLE 0.03 X 45°
  2. INSERT D2649 SPACER
  3. WELD INTO PLACE AND GRIND FLUSH
  4. CBORE TO 0.313 X 0.75 DP (EXCEPT WHERE INDICATED)

**SECTION D-D**  
A4-2  
A4-3  
FOR 0.375 HOLES ONLY  
SCALE NONE

|  |          |   |              |
|--|----------|---|--------------|
| DESIGN   | 97       | <b>DART AEROSPACE USA, INC</b>              |              |
| DRAWN  | 1        | PORT HADLOCK, WA                            |              |
| CHECKED  | 2        | DRAWING NO.                                 | REV. A       |
| MFG. APPR.   | 3        | D3804                                       | SHEET 4 OF 5 |
| APPROVED   | 4        | TITLE                                       | SCALE        |
| DE APPR.   | 5        | SKIDTUBE ASSEMBLY, 206A/B                   | NTS          |
| DATE   | 08.07.07 | COPYRIGHT © 2008 BY DART AEROSPACE USA, INC |              |
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| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                                |                                 |                |                           |                       |                          |
|------|------|----------------------------------|--------------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action<br>Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng           | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                                |                                 |                |                           |                       |                          |
|      |      |                                  |                                |                                 |                |                           |                       |                          |
|      |      |                                  |                                |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries



79270

RELEASED  
97 09.03.03

CCR264SS3-3  
RIVET  
2 PL

CR3212-4-03 RIVET  
2 PL

**VIEW G-G**  
SCALE NONE

A7-5

D2647 CAP, TO INSTALL:  
1. CUT TUBE LEVEL  
2. REMOVE RIDGE ON FWD SIDE  
3. LOCATE D2647 (TRIM AS REQD)  
4. WELD D2647 IN PLACE  
5. GRIND FLUSH  
6. RIVET D2680-041 NUT PLATE  
IN PLACE

MS27039-4-06 SCREW  
AN960JD416 WASHER

D2680-041  
NUTPLATE

C7-5

1.0 REMOVE RIDGE ON  
INSIDE OF SKIDTUBE  
LEAVE 0.070 MIN.

**DETAIL E**  
SCALE NONE

B7-2  
B7-3

0.400

END OF WEB

BORE OUT END  
OF SKIDTUBE  
TO 0.75 DEPTH  
AND 0.070 WALL

SEAL WITH  
SIKAFLEX-241/291

D2646 AFT CAP

Ø0.204  
REF

MS27039-1-08 SCREW  
AN960JD10L WASHER  
2 PL

**DETAIL F**  
SCALE NONE

B2-2  
B2-3

|            |          |  |              |
|------------|----------|--|--------------|
| DESIGN     | 97       | <b>DART AEROSPACE USA, INC</b>   |              |
| DRAWN      | 97       | PORT HADLOCK, WA   |              |
| CHECKED    | 97       | DRAWING NO.  | REV. A       |
| MFG. APPR. | 97       | D3804  | SHEET 5 OF 5 |
| APPROVED   | 97       | TITLE  | SCALE        |
| DE APPR.   | 97       | SKIDTUBE ASSEMBLY, 206A/B  | NTS          |
| DATE       | 08.07.07 | <small>COPYRIGHT © 2008 BY DART AEROSPACE USA, INC<br/>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS<br/>NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED TO ANY OTHER PERSON WITHOUT<br/>WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small> |              |

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries

NO. 281

AWS D17.1.2001  
QUALIFICATION TEST RECORD

Name: Borclay Elliot  
Job number: 77988  
Part number: A206-642-151  
Description: SPRINT  
Welding Process: Tig[ ☒ ] Mig[ ☐ ]  
Base material: Aluminium  
Current: AC[ ☒ ] DC[ ☐ ]

TEST REQUIREMENTS AND RESULTS

Visual: pass[ ☒ ] fail[ ☐ ]  
Penetration: pass[ ☒ ] fail[ ☐ ]

UNACCEPTABLE

Cracks: pass[ ☒ ] fail[ ☐ ]  
Undercut: pass[ ☒ ] fail[ ☐ ]  
Pin holes: pass[ ☒ ] fail[ ☐ ]  
Overlap (cold lap): pass[ ☒ ] fail[ ☐ ]  
Porosity (surface): pass[ ☒ ] fail[ ☐ ]  
Coloration: pass[ ☒ ] fail[ ☐ ]

Qualifier [Signature] Date of Test Coupon 12-01-23  
Welder Borclay Elliot Date of Test Coupon 12-01-23

The above named individual is qualified in accordance with AWS D17.1.2001 to weld